ABSTRACT OF THE DISCLOSURE

A multi-lap mold manufacturing system includes an overhead rail circuit upon which a multiple of molds transit a closed loop for a multiple of laps. The system is separated into Zones in which a particular mold operation is performed relative to which lap each of the plurality of molds has completed. At least one of the Zones is a spray Zone in which the mold is sprayed robotically. Robot utilization is extremely high as multiple spray operations occur in but a few spray Zones. Application of exceedingly expensive environmental emission control devices is at least partially mitigated by the reduced number of spray stations and the much smaller factory footprint. Consolidation of multiple spray operations into a few spray Zones also advantageously simplifies the control of chemical and ambient variables which improves production efficiencies and reduces operator dependency.

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